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The following is replacement paragraph 33, without any underlining:

"33. The preferred form of alum is known as "papermakers" alum. "Paper makers" alum is a clear, light green to light yellow aqueous solution containing about 48.5% aluminum sulfate, on a dry basis. The chemical formula is $\text{Al}_2(\text{SO}_4)_3 \cdot 18 \text{H}_2\text{O}$. Alum is also preferred because it tends to accelerate the rehydration of the hemihydrate crystals. Typically, about 0.10% of alum is used for rehydration of the hemihydrate to the dihydrate in the formed composite. For use as a crystal modifier in the present invention, about one liter of papermaker's alum per 100 gallons of gypsum/fiber slurry (about 0.4% solids based on the total slurry) is sufficient to overcome problems caused by impurities. The optimum dosage is sufficient alum to provide the highest board hardness."